

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014321**Date Inspected:** 23-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Zhu Tian Shu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

BAY-1

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) welding of weld joint 20TR2-028-015. Welder is identified as 251246. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

FCAW welding of weld joint 20TR2-036-017. Welder is identified as 216872. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

FCAW welding of weld joint 20TR1-039-003. Welder is identified as 059450. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

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FCAW welding of weld joint 20TR2-039-011. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

BAY-2

Submerged Arc Welding (SAW) welding of weld joint FB3186-001-006. Welder is identified as 045265. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-U3c-S-2.

FCAW welding of weld joint FB3186-001-002. Welder is identified as 045203. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-B- U3a-F-1.

BAY-3

FCAW Tack welding of weld joint FB3106-001-035. The tack welder is identified as 208035. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu. The welding variables appeared to comply with the Applicable Welding Procedure Specification (WPS): WPS-B-P-2231-B-U2-F-1.

BAY-5

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005583.

Visual Testing (VT)

This QA Inspector performed VT of the area previously tested and accepted by ZPMC QC Personnel. The member is identified as OBG Cable tray support weld Components. The component designations are review as follows:

1. CTS1D1 (d).
2. CTS1D1 (g).
3. CTS1E1 (b,e,g,h).
4. CTS1F (a,b,c,d).

BAY-6

Shielded Metal Arc Welding of weld joint WJF-0-008. Welder is identified as 037998. ZPMC Quality Control (QC) is identified as Mr. Zhao Jian Hang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3312-TC-P5.

BAY-8

FCAW welding of weld joint BK004A6-063-094. Welder is identified as 500405. ZPMC Quality Control (QC) is identified as Mr. Yang Qiang feng. The welding variables recorded by QC appeared to comply with the Applicable

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WPS: WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
